

# RAZORGAGE

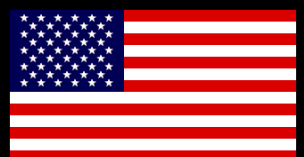
POSITIONERS • SOFTWARE • SYSTEMS



## AUTO-PUSHER SAW SYSTEM

Proudly Made in Ames, Iowa, U.S.A.

[www.razorgage.com](http://www.razorgage.com)



# RazorGage Automatic Pusher System

- Download cutlists directly to the RazorGage PC via Ethernet, WiFi or USB drive.
- Optimize at the machine or run pre-optimized lists from most popular software.
- Optionally print paper labels or inkjet print directly on the parts.
- Sort cutlists right at the machine.
- Includes the revolutionary Cyclone Upcut Saw made in America by RazorGage.
- Select solid PVC over steel table top, PVC rollers or steel rollers.
- RazorGage solid state PC - running Windows 8.1Pro
- Includes 21" Color LCD Multi-Touch Screen .
- Optional articulated pusher mounted gripper.
- Aluminum cutting option includes Dual Mist Blade Lubricator. Front to back adjustable top clamp accessory also available.

AutoList Package includes Parts List Processor cut list management software allowing you to map nearly any comma, semi-colon, or tab separated text file for downloading to the RazorGage. Cutlists from your design software can be merged, edited, or simply sent directly to the machine. You can even send different parts to different machines automatically! Once at the machine parts are sorted into groups for your operator to select. Pre-optimized cutlists are grouped according to bar number. As parts are cut their quantity is automatically decremented and are crossed off the list when their quantity reaches zero. The Qty+ button allows the operator to easily bring a part back alive or to simply adjust the quantity. The operator simply enters the length of clear material available and the AutoList finds the optimal cutting solution. Press GO, stand back, and watch the magic. Precision cut parts will begin queuing up on the outfeed table in no time flat! .

The image displays two screenshots of the Standard PC Positioning Software v7.9.39 interface, Serial Number: Demo Version.

**Left Screenshot: PART GROUPS**

Current Pos: 0.000 **AutoList Pusher Mode** Switch to Stop Mode SETTINGS MAIN

Offset: NONE ENTER LENGTH 120 USE LENGTH 120

OPEN FILE QTY + QTY - ENTER QTY

CLOSE FILE NEXT GROUP PREV GROUP GROUPING LIST

Total QTY for All Parts: 188 Part Grouping 2 of 2

Group #	MATERIAL	QUANTITY	LENGTH
1	1010-72	94	265.4
2	1530-48	94	1,205.4

SELECT

CANCEL

1010-72

**Right Screenshot: AutoList Pusher Mode**

Current Pos: 0.000 **AutoList Pusher Mode** Switch to Stop Mode SETTINGS MAIN

Offset: NONE ENTER LENGTH 120 USE LENGTH 120

OPEN FILE QTY + QTY - ENTER QTY

CLOSE FILE NEXT GROUP PREV GROUP GROUPING LIST

Total QTY for All Parts: 188 Part Grouping 2 of 2

MATERIAL	QUANTITY	LENGTH	FINISH
1530-48	94	1,205.4	
1530-48	12	14.385	Black
1530-48	14	13.75	Black
1530-48	12	13.125	Black
1530-48	10	12.75	Black
1530-48	12	12.625	Black
1530-48	10	12.125	Black
1530-48	14	11.875	Black
1530-48	10	11.625	Black

1530-48

C:\Users\Dave\Desktop\Sample Cutlist\FabTechDemo.ndb

14.385 in.  
Elevation: .FV2  
Customer: FabTechDemo

# RazorGage Automatic Pusher System

Standard PC Positioning Software v7.9.39 Serial Number: Demo Version

PUSHER MODE - RUNNING A BOARD ☒ Automatic Part Cut

#	DONE	MATERIAL	LENGTH	FINISH
1	NO	1530-48	14.385	Black
2	NO	1530-48	14.385	Black
3	NO	1530-48	14.385	Black
4	NO	1530-48	14.385	Black
5	NO	1530-48	14.385	Black
6	NO	1530-48	14.385	Black
7	NO	1530-48	14.385	Black
8	NO	1530-48	14.385	Black

Running a Board

LOAD OUT

CANCEL RUN

Adjust Kerf

1 2 3 4 5 6 7 8

Be up and running in no time. Software is intuitive and setup & training are included.

Defines how parts are sorted into categories

Select the fields used to define different feed stocks

Available fields

- UF\_8
- WIDTH
- THICKNESS
- PART
- MARK
- CABINET NUM
- UF\_5
- SEQ\_NUM
- UF\_7
- UF\_20
- HOLES FROM FRONT
- HOLES FROM TOP
- HOLES FROM BOTTOM
- DETAIL #
- UF\_15
- UF\_16
- UF\_17

MATERIAL  
FINISH  
BAR #  
ELEVATION

Shift Up

Shift Down

Update Stock Definition

DONE

Stock definition: Parts are sorted by first item, then second item, then third item, etc.

Sorting your cutlist into groups is easy. Change grouping mid-run right at the machine.



# RazorGage Automatic Pusher System

The Batch Screen is included with the Standard PC RazorGage software at no additional charge. It allows the operator to enter and save production runs as quick as can be. With the RazorGage Batch Screen you can define a run by a Part Number, Material Type & Part Length. Leading edge trim cuts, run quantity, number of sticks per run, and stock length can be changed independently of the saved run definition if needed.

To add a part/material configuration click CREATE NEW PART.

0.000

Batch Parts Screen

Exit to Main Screen

Create New Part Edit Selected Part

Part Number (Filename)

Trim Cut .500 Change

Desired Quantity 0 Change

# of Stock Pieces Loaded 5 + -

Completed Parts 0 Reset

LINE UP

LINE DOWN

USE A NEW STOCK LENGTH

USE LAST STOCK LENGTH (96)

RUN RESUME PAUSE CANCEL

Enter a name for the part / material configuration, the length of the parts you want to cut, and the material designation that will tell the operator what kind of stock to use. Then press Save.

Batch Part Entry Screen

Part Number. (Filename) test1

Cut Length 24.375

Material Type AL6064T-534

1 2 3 4 5 6 7 8 9 0 - BACKSPACE

TAB q w e r t y u i o p

CAPS a s d f g h j k l

SHIFT z x c v b n m . SHIFT

SPACE BAR

Save Cancel

# RazorGage Automatic Pusher System

Once you have entered your part lengths and material types they will appear in the white box at the left of the Batch Parts Screen. Choose a part to bring up that part's information as shown below.

Enter the leading edge trim cut length here. This is a global variable that will stay constant regardless of which part you choose. It may be changed at any time by pressing the CHANGE button.

Press the + or - button to change the number of stock pieces you are going to push. This will enable the software to keep a count of how many finished pieces you've cut.

Enter the desired quantity for the current run here by pressing the CHANGE button.

The screenshot shows the 'Batch Parts Screen' of the 'Standard PC Positioning Software v7.6.2'. The interface includes a top status bar with '0.000' and 'Exit to Main Screen' button. On the left, there are buttons for 'Create New Part' and 'Edit Selected Part', and a list of files: 'test1.txt', 'test2.txt', and 'test3.txt'. Below the file list are 'LINE UP' and 'LINE DOWN' buttons. The main area displays 'Part Number (Filename)' as 'test1', 'Cut Length' as '24.375', and 'Material Type' as 'AL6064T-534'. On the right, there are fields for 'Trim Cut' (.500), 'Desired Quantity' (0), and '# of 'Stock Pieces' Loaded' (5), each with a 'Change' button. Below these are 'Completed Parts' (0) and a 'Reset' button. At the bottom, there are four large buttons: 'USE A NEW STOCK LENGTH', 'USE LAST STOCK LENGTH (96)', 'RUN', 'RESUME', 'PAUSE', and 'CANCEL'.

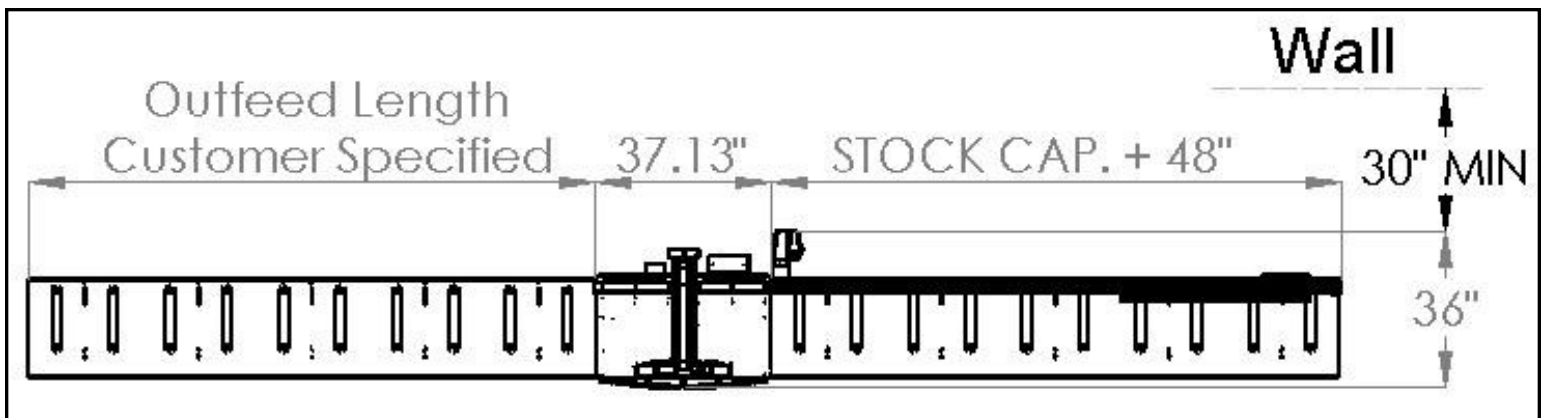
Press the USE A NEW STOCK LENGTH to tell the RazorGage how long of a piece you will be introducing to the machine.

Press the USE LAST STOCK LENGTH to tell the machine that you will be feeding the same size stock that you had previously entered.

# Specifications

Motor Specs	7.5 hp (enclosed fan cooled) available in 208-230-460Vac 3-phase
Power Source	230 VAC, 3 phase, 30 Amps 460 VAC, 3 phase, 20 Amps
Exhaust Port	Two 4" diameter (102 mm) requiring 600 cfm (17 m <sup>3</sup> ) minimum for drylight materials. Other material may need higher velocity/pressure
Compressed Air	Requires 80 psi (5.5 bar) at 5 cfm (0.14 m <sup>3</sup> ) air filtered to 2.5 microns (oil and moisture free). Use industrial air dryer, rated for cfm (CM) flow. No lubrication required for air components. Air must be lubricant free.
Motor RPM	Adjustable up to 3450
Arbor	1.000 inch
500 mm Blade for Wood	500mm x 120T x 1" Bore x 23°ATB/5°ASF x Plate .128 x Kerf .172
500mm Blade for Aluminum	O/D 500mm or 19.68" x Kerf 3.5mm or .137" x Plate 3.0mm or .118" x Bore 25.4mm or 1.00" x Teeth 140 D Type Tip Grade Sash Pro X Expansion Slots Five.
24" Blade for Wood	24" Dia. x 144T x 1" Bore x 23°ATB/5°ASF x Hook 22° Plate.138 x Kerf.186
24" Blade for Aluminum	24" Dia. x 200 Teeth x 1" Bore x TCG x Hook 6° Plate.138 x Kerf.174

Material Thickness	Cyclone 600 Width Capacity for Common Blade Diameters					
	14" Blade	16" Blade	18" Blade	500mm Blade	22" Blade	24" Blade
0.5	6.97	10.38	13.23	15.42	18.27	20.62
0.75	6.04	9.77	12.76	15.02	17.93	20.32
1	4.89	9.10	12.25	14.59	17.57	20.00
1.25	3.32	8.35	11.70	14.13	17.19	19.67
1.5		7.49	11.10	13.64	16.79	19.32
1.75		6.49	10.44	13.11	16.36	18.95
2		5.25	9.72	12.54	15.90	18.55
2.25		3.56	8.91	11.92	15.42	18.14
2.5			7.98	11.24	14.90	17.70
2.75			6.90	10.50	14.35	17.24
3			5.58	9.68	13.75	16.74
3.25			3.78	8.75	13.11	16.22
3.5				7.68	12.42	15.67
3.75				6.40	11.67	15.08
4				4.75	10.84	14.45
4.25				1.99	9.92	13.77
4.5					8.88	13.03
4.75					7.68	12.24
5					6.20	11.37
5.25					4.20	10.40
5.5						9.30
5.75						8.03
6						6.49



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